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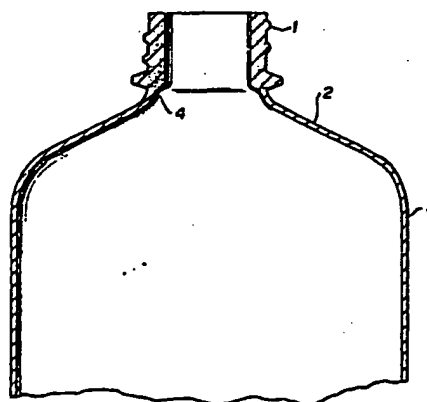
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(64) Blow-moulded bottle-shaped container of biaxially oriented polyethylene terephthalate and piece to be blow-moulded into the same bottleshaped container.

(57) A hollow blow-moulded bottle-shaped container of a biaxially oriented polyethylene terephthalate which advantageously has a stepped portion (4) formed on the inner peripheral surface of a boundary between a neck portion (1) integrally formed with a shoulder portion (2) with a body portion (3) and the shoulder portion (2) and crystallized by a heat treatment before being biaxially oriented blow-molded from an injection-molded primary piece or parison (P), thereby abruptly reducing the thickness of the wall at the boundary from the neck portion (1) to the shoulder portion (2) to substantially equal to the thickness of the body portion (3). This bottle-shaped container is manufactured from a preformed piece or parison (P) injection-moulded in which a recess groove is formed on the peripheral surface of the shoulder portion forming portion (2a). Thus, the deterioration in the physical properties of the neck portion and shoulder portion of the bottle-shaped container can be eliminated.

FIG. 1



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This invention relates to a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin and a piece or parison to be blow-molded into the same bottle-shaped container.

Since a blow-molded bottle-shaped container of biaxially oriented polyethylene terephthalate resin, hereinafter referred to as "a PET", has a number of excellent physical properties and characteristics, it has a wide range of application in a great deal of quantity.

Some of excellent physical properties of a bottle-shaped container of a PET can be performed after the bottle-shaped container has been biaxially oriented and blow-molded. The bottle-shaped container of the PET has heretofore been produced due to the physical properties of the PET by the steps of injection-molding a piece or parison as a primary or prefabricated molded piece and then biaxially orienting the primary piece or parison, so-called an injection blow-molding method. Thus, the neck portion of the bottle-shaped container used as a mounting portion to a blowing mold has not entirely been oriented but been molded from the primary piece or parison to the hollow blow-molded bottle-shaped container. In this manner, the shoulder portion continued to the neck portion of the bottle-shaped container has not thus been sufficiently oriented in the course of the injection blow-molded method but been blow-molded to the final bottle

shap . Accordingly, the neck portion and the shoulder portion of the bottl -shaped container cannot p rform th excellent physical prop rties of th PET prepared by being subj cted to the biaxially blow-molding method.

The drawbacks and disadvantages of the bottle-shaped container of the final shape thus blow-moldéd at the neck portion and shoulder portions which have not been subjected to or sufficiently subjected to an orientation are, for example, a crazing which occurs due to the impregnation of alcohol in high density to the bottle-shaped container, a feasibility of various deformations and strains including elongation due to lack of sufficient hardness of the bottle-shaped container, and a low thermal resistance due to the occurrence of thermal deformation simply taken place in the case that a content liquid is filled at a high temperature in the bottle for the purpose of sterilization. More concretely, the neck portion and the shoulder portion of the conventional bottle-shaped container thus blow-molded has such drawbacks and disadvantages that, when high internal pressure is applied to the bottle-shaped container such as in the case that carbonated drink mixed with fruit juice is contained as a content liquid by a hot charging process, the shoulder portion molded without being subjected to sufficient orientation is axially elongated and deformed by the internal pressure.

Accordingly, an object of the present invention is to provide a hollow blow-molded bottle-shaped container of a biaxially orient d polyethylene ter phthalate resin which can eliminate all the aforementioned drawbacks and disadvantages

of the conventional bottle-shaped container and which has less deterioration in the physical properties of the neck portion and shoulder portion thereof.

Another object of the present invention is to provide a hollow-blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin in which the neck portion is crystallized to have a sufficient hardness and the shoulder portion is sufficiently oriented in the blow-molding, thereby eliminating a crazing occurred due to the impregnation of alcohol in high density to the bottle-shaped container.

A further object of the present invention is to provide a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin in which the mechanical strength and chemical resistance can be enhanced.

Still another object of the present invention is to provide a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin in which uniform physical properties can also be provided at the neck portion in the same manner as the body of the bottle-shaped container, thereby eliminating the axial elongation of the shoulder portion due to the internal pressure applied to the container and the deterioration in the thermal resistance at the shoulder portion thereof.

Still another object of the present invention is to provide a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin in which the excellent physical properties of the polyethylene terephthalate resin can be entirely uniformly performed.

Still another object of the invention is to provide

a piece or parison to be blow-molded into a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin having a stepped portion on the inner peripheral surface of a boundary between the neck portion and the shoulder portion for strengthening the shoulder portion.

The above and other related objects and features of the invention will be apparent from a reading of the following description of the disclosure found in the accompanying drawings and the novelty thereof pointed out in the appended claims.

Fig. 1 is an elevational side view of the neck portion of a bottle-shaped container according to an embodiment of the present invention;

Fig. 2 is an elevational side view of a piece or parison to be blow-molded into the bottle-shaped container according to another embodiment of the present invention; and

Fig. 3 is an elevational side view of a piece or parison to be blow-molded into the bottle-shaped container according to still another embodiment of the present invention.

The present invention will now be described in more detail with reference to the accompanying drawing.

A hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin (PET) according to the present invention includes, similarly to the conventional bottle-shaped container of this type, a cylindrical body 3 with a bottom, a tapered cylindrical wall-shaped shoulder portion 2 integrally formed from the upper end of the body 3, and a neck portion 2 stood on the

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upper end of the shoulder portion 2.

According to the present invention, the neck portion 1 of the bottle-shaped container is already crystallized by a predetermined heat treatment before a primary preformed piece or parison prepared by an injection molding is biaxially oriented in a blow molding and hence in the state of the primary preformed piece or parison, The shoulder portion 2 of the bottle-shaped container is sufficiently axially oriented so that the thickness of the wall of the shoulder portion 2 becomes substantially equal to that of the body 3 over the entire shoulder portion 2. Further, in order that the thickness of the shoulder portion 2 is formed to be substantially equal to that of the body 3, a stepped portion 4 is formed on the inner peripheral surface of the boundary between the neck portion 1 having a large thickness and the shoulder portion 2 to thereby abruptly reduce the thickness of the wall at the boundary from the neck portion 1 to the shoulder portion 2 in the vicinity of the shoulder portion 2 from the neck portion 1.

According also to the present invention in the method of manufacturing a hollow bottle-shaped container of a biaxially oriented polyethylene terephthalate resin having the stepped portion on the inner peripheral surface of the boundary between the neck portion and the shoulder portion, the stepped portion 4 is formed by the steps of sufficiently orienting the shoulder portion 2 in the blow molding, crystallizing the neck portion 1 of the PET material so that the neck portion 1 is not entirely oriented nor deformed, and blow-molding radially the shoulder portion 2 and the body 3 of the bottle-shaped container.

The bottle-shaped container of the structure described above according to the present invention is manufactured, similarly to the conventional biaxial orientation blow molding method, by the step of biaxially orienting a primary preformed piece or parison prepared by an injection molding.

According to the present invention, the neck portion of the primary injection-molding piece or parison is heat treated prior to the biaxial orientation blow molding to thereby crystallize the neck portion prior to the blow molding different from the conventional case.

Further, it is preferred in order to impart smoothly an orientation blow molding to the portion of the injection-molded piece or parison to be formed with the shoulder portion 2 that the thickness of the wall of the portion directly under the neck portion thus crystallized of the piece or parison is reduced than the other portion so as to concentrate the orientation force applied in case of axially orienting the piece or parison in the blow molding to the portion directly under the neck portion of the piece or parison.

The piece of parison thus constructed will now be described in more detail according to preferred embodiments of the present invention with reference to Figs. 2 and 3. In the piece or parison P, a shoulder portion forming portion 2a as the boundary portion between a body forming portion 3a and the neck portion 1 is formed sufficiently thin as compared with the body forming portion 3a.

Further, the neck portion 1 is crystallized by a predetermined heat treatment prior to the biaxial orientation blow-molding of the piece or parison P into a bottle-shaped container.

In a structure of the piece or parison P in which the thickness of the shoulder portion forming portion 2a is reduced, a recess groove may be formed on the outer peripheral surface of the shoulder portion forming portion 2a as shown in Fig. 2, or a recess groove is formed on both inner and outer peripheral surfaces of the shoulder portion forming portion 2a of the piece or parison P as shown in Fig. 3. According to the structure of an injection molding die for the piece or parison P, the recess groove is formed on the outer peripheral surface of the shoulder portion forming portion 2a of the piece or parison P as shown in Fig. 2 is most preferably performed.

As described above, when the portion directly under the neck portion of the piece or parison thus crystallized is reduced in thickness in advance, an orientation force applied in case of axially orienting the piece or parison is concentrated at the thinned portion or stepped portion thus formed, thereby early orienting the thinned portion of the piece or parison in the blow molding.

The orientation blow molding of the thinned portion of the injection-molded piece or parison in a predetermined amount has been completed much earlier than the time when the piece or parison has been entirely oriented and blow-molded. Accordingly, the axial orientation blow-molding of the piece or parison is subsequently continued for the other portion of the piece than the thinned portion of the piece even after the orientation blow-molding of the thinned portion has been completed.

While the thinned portion of the piece is orientation blow-molding, the other portion of the piece is simultaneously

orientation blow-molding. In this case, the thinned portion of the piece is oriented much faster in the orientation quantity per unit time than the other portion of the piece. Accordingly, the orientation amount of the thinned portion of the piece can reach much earlier than the other portion of the piece the predetermined quantity.

As described above, the orientation blow-molding is early concentrated at the portion directly under the neck portion of the piece or parison. However, the neck portion of the piece is already heat treated to be crystallized. Accordingly, the neck portion thus crystallized is not oriented at all, so that the intermediate portion between the neck portion and the portion directly under the neck portion thus oriented of the piece is abruptly varied or reduced in thickness with the result that a stepped portion is formed at the boundary portion between the neck portion and the portion directly under the neck portion of the piece.

In this case, subsequent to or simultaneously upon axial orientation blow-molding of the piece or parison, compressed air is introduced into the hollow piece or parison to radially orient the piece to thus completely biaxially orient the piece into a bottle-shaped container.

In the case that the piece is radially blow-molded, the portion to be formed in a shoulder portion 2 of the piece is also externally subjected to an orientation force. In this manner, the stepped portion 4 formed between the neck portion 1 and the shoulder portion 2 of the piece is formed only on the inner peripheral surface side of the bottle-shaped container.

In the embodiment described above, the bottle-shaped

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container of the present invention is manufactured by the step of crystallizing the neck portion 1 of the piece or parison injection-molded. Therefore, the bottle-shaped container of the present invention has sufficient hardness at the neck portion and does not cause a crazing due to the impregnation of alcohol in high density to the bottle-shaped container. The shoulder portion 2 of the bottle-shaped container is thus subjected to sufficient orientation. Accordingly, the shoulder portion 2 can exhibit the similar physical properties to the body 3 sufficiently orientation blow-molded.

As evident from the foregoing description, the bottle-shaped container according to the present invention has the neck portion 1 crystallized to enhance the mechanical strength and the chemical resistance and the shoulder portion 2 oriented in the same quantity as the body 3. Therefore, the body of the bottle-shaped container under the neck portion 2 incorporate in the uniform physical properties. Thus, the shoulder portion 2 of the bottle-shaped container of the invention is not axially oriented or deformed by the action of the internal pressured applied to the container. Further, the drawback that the shoulder portion 2 has deteriorated in the thermal resistance can be eliminated, and the excellent properties of the polyethylene terephthalate resin can be entirely uniformly performed in the bottle-shaped container of the present invention.

1. A hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin characterised by

(a) a cylindrical body with a bottom,

(b) a tapered cylindrical wall-shaped shoulder portion integrally formed from the upper end of said body,

(c) a neck portion integrally formed on the upper end of said shoulder portion and crystallized by a heat treatment before being biaxially oriented blow-molded from an injection-molded primary piece or parison, and

(d) a stepped portion formed on the inner peripheral surface of a boundary between said neck portion and said shoulder portion to thereby abruptly reduce the thickness of the wall at the boundary from said neck portion to said shoulder portion in the vicinity of said shoulder portion from said neck portion to substantially equal thickness to that of said body portion thereof.

2. A preformed piece or parison injection-molded into a cylindrical shape with a bottom to be blow-molded into a hollow blow-molded bottle-shaped container of a biaxially oriented polyethylene terephthalate resin characterised

by a shoulder portion forming portion crystallized by a predetermined heat treatment and located between a neck portion and a body forming portion in such a manner that the thickness of the wall thereof is formed smaller than the thickness of the wall of said body forming portion.

3. The preformed piece or parison according to claim 2, wherein a recess groove is formed on the outer peripheral surface of said shoulder portion forming portion.

4. The preformed piece or parison according to claim 2,

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wherein a recess groove is formed on the inner peripheral surface of said shoulder portion forming portion.

5. The preformed piece or parison according to claim 2, wherein recess grooves are formed on both the inner and outer peripheral surfaces of said shoulder portion forming portion.

FIG. 1

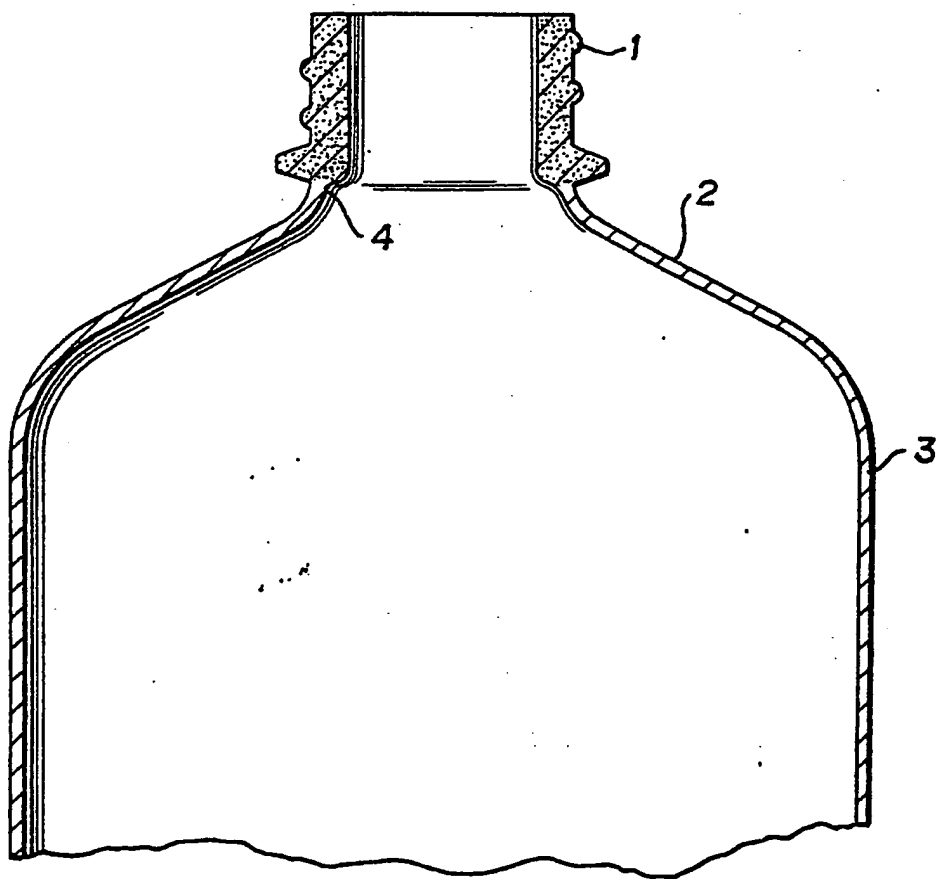


FIG. 2

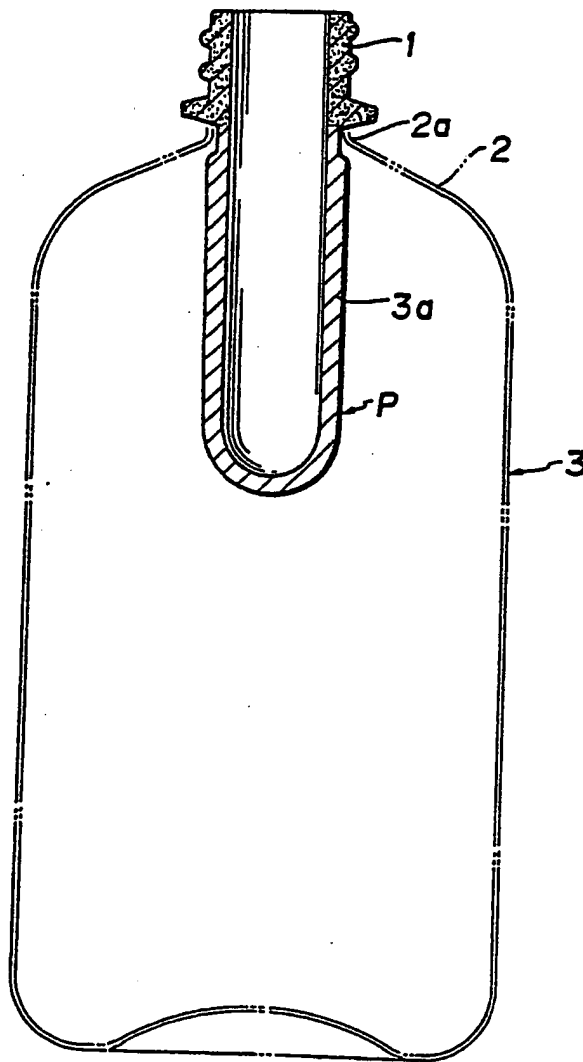
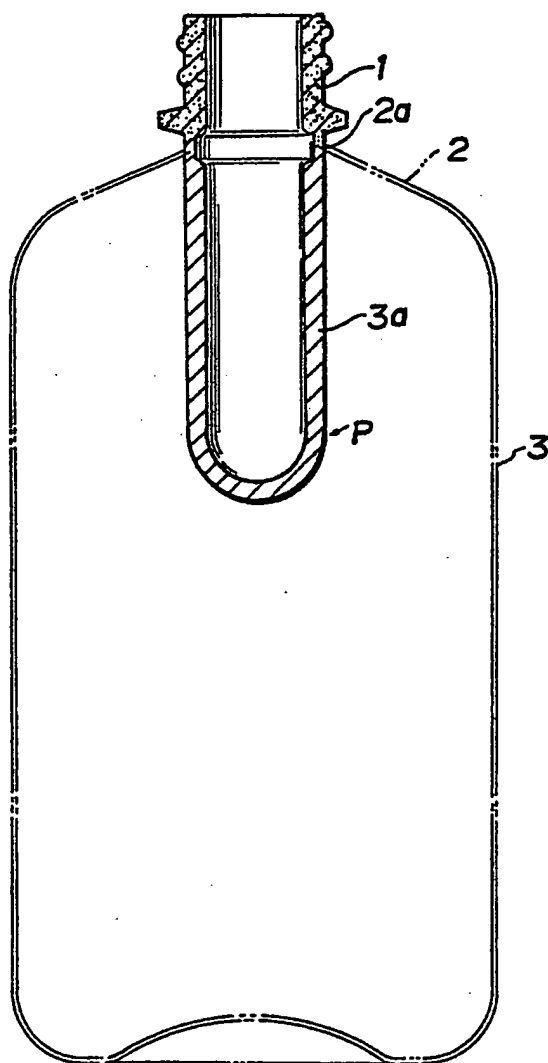


FIG. 3





European Patent
Office

EUROPEAN SEARCH REPORT

0074246
Application number

DOCUMENTS CONSIDERED TO BE RELEVANT			EP 82304599.2
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 7)
A	<u>US - A - 4 256 789 (SUZUKI et al.)</u> * Totality, especially column 2, lines 58-65 * --	1-5	B 65 D 1/02 B 29 C 17/07
A	<u>GB - A - 2 034 663 (YOSHINO KOGYOSHO CO)</u> * Fig. 7,8 * --	1,2,4	
A	<u>DE - A1 - 2 910 609 (VEREINIGTE VERPACKUNGSGESELLSCHAFT m.b.H.)</u> * Fig. 1,2,4; page 8, lines 10-28 * --	2-4,5	
A	<u>DE - A1 - 2 746 951 (YOSHINO KOGYOSHO CO)</u> * Fig. 2,4 * --	1,2	TECHNICAL FIELDS SEARCHED (Int. Cl. 7) B 65 D 1/00 B 65 D 23/00 B 65 D 85/00 B 29 C 17/00 B 29 D 23/00
A	<u>GB - A - 1 303 599 (PEPSICO, INC.)</u> * Fig. 2 * --	1	
A	<u>DE - A1 - 3 002 189 (YOSHINO KOGYOSHO CO)</u> * Fig. 1,3,5,8 * & GB-A-2 042 408 ----	1,2	
X The present search report has been drawn up for all claims			
Place of search VIENNA		Date of completion of the search 11-11-1982	Examiner CZUBA
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			